

Work Order ID 63906

Thursday, November 18, 2010 3:40:32 PM



Page 1

Item ID: D3536-13

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 11/19/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/26/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-11-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B10-11-30



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Scot 11/30

7/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63906

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Page 2

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Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 11/19/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 11/26/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **FP11**

0.00



Packaging

Memo

0.00

Packaging

10/11/30 SP (120)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/01 9/12
R/O-11-30
(12)

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Picklist Print

Page 1

Thursday, November 18, 2010 3:40:31 PM

Work Order ID: 63906



Parent Item: D3536-13



Parent Item Name: Gasket

Start Date: 11/19/2010

Required Date: 11/26/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	391.6220	0.8269	11.02533			



AB10-11-30

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT

391.622

115500

75.622

115916

316

115916

12

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 63906
Description: Gasket		Part Number: D3536-13
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	X		T HB61	
29.40	+/-0.030	29.40	X		T	
27.40	+/-0.030	27.40	X		T	
23.90	+/-0.030	23.90	X		T	
18.98	+/-0.030	18.98	X		T	
14.07	+/-0.030	14.07	X		T	
9.15	+/-0.030	9.15	T		T	
5.65	+/-0.030	5.65	T		T	
3.90	+/-0.030	3.90	X		T	
8.00	+/-0.030	8.00	X		T	
14.00	+/-0.030	14.00	T		T	
20.00	+/-0.030	20.00	T		T	
1.89	+/-0.030	1.888	X		V HB02	
0.30	+/-0.030	0.300	X		V	
0.30	+/-0.030	0.303	X		V	
Ø0.19	+0.005/-0.001	0.190	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-11-30	Date: 10/4/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	B

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

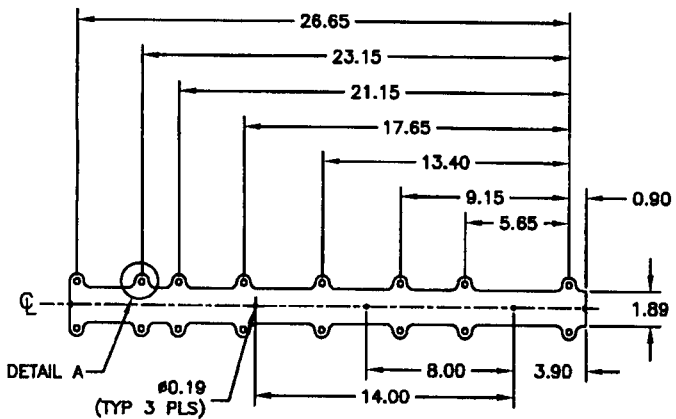
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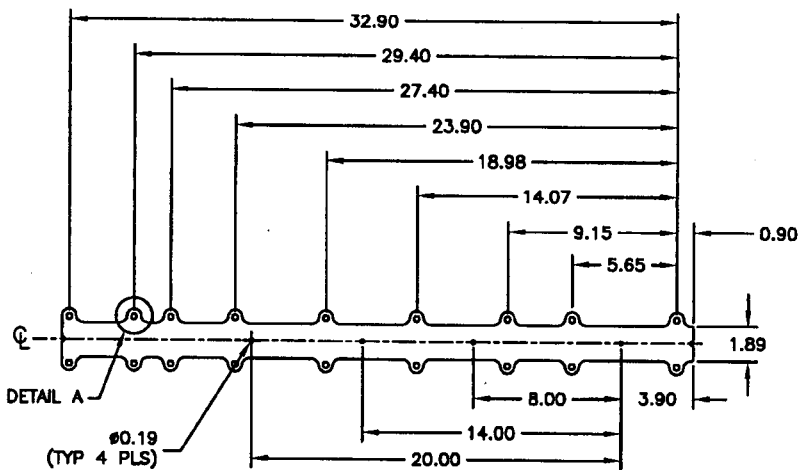
DART

09.02.12-#

#63906



D3536-11 GASKET




D35.36-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH		D3536	SHEET 1 OF 6
DATE	TITLE		SCALE
06.10.25	GASKET		1:10
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
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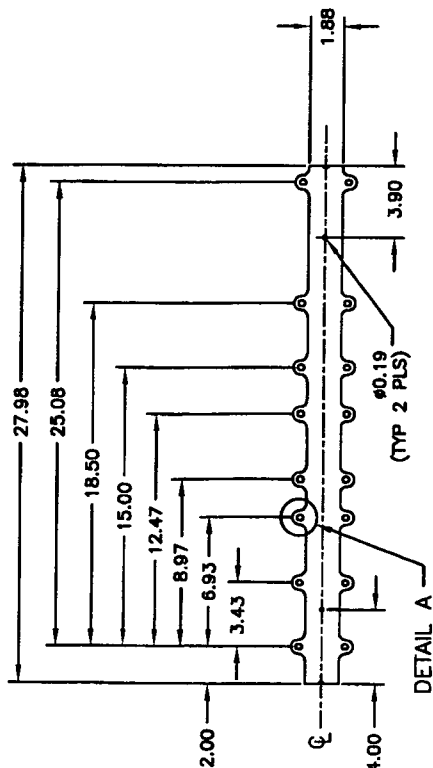
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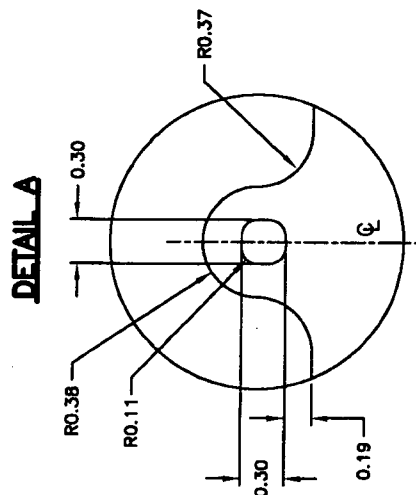


DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

RELEASED
07.02.12 *[Signature]*



D3536-41 GASKET



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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